

Date: Tuesday, 3/20/2007 1:52:06 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FWD X-TUBE EXTENDED HEIGHT GEAR (-011)
Job Number : 31372	
Estimate Number : 10007	
P.O. Number : <i>N/A</i>	Part Number : D205596101
This Issue : 3/20/2007 S.O. No. : <i>N/A</i>	Drawing Number : D205-596-101 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : LANDING GEAR	Drawing Revision : A
Previous Run : 29064	Material : <i>N/A</i>
Written By : _____	Due Date : 4/15/2007 Qty: 1 Um: Each
Checked & Approved By : <i>07.03.20</i>	
Comment : Est Rev G Removed Bending 05-10-25 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy D205-594 bluefile & type labels per PPP D205-596-101 CHG001

KS 07.04.03 (1)

2.0	D2889	FWD Crosstube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

FWD Crosstube

Pick:

Qty Part number Description Batch

1 D2889 Fwd Crosstube *31364*
EL 7-3-27

3.0	BENDING	BENDING MACHINE
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Comment: BENDING MACHINE

Bend as per Dwg D2889

EL 7-3-27

4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

Mark *38.5* for cutting from tangential line in the straight section from D2889 as per Dwg wall template. *21 07-03-28*

5.0	QC15	DIMENSIONAL CHECK OF X-TUBES
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Comment: DIMENSIONAL CHECK OF X-TUBES

0703-28 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/20/2007 1:52:06 PM
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Drawing Name: FWD X-TUBE EXTENDED HEIGHT GEAR (-011)

Job Number: 31372

Part Number: D205596101

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut as per Dwg D205-596-101

DP 7-4-2

JD 7-4-2

2-Deburr & Inspect for surface damage. Polish cut surface. Scribe part # and end of tube.

Batch # on one

7.0

QC 5

DIMENSIONAL CHECK OF X-TUBES



2004.02 @



Comment: DIMENSIONAL CHECK OF X-TUBES

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat per QSI 005 4.1

JD 7-4-2

9.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

Prime inside and outside with Immron per QSI 005 4.2

45 07 04 26

10.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

07.05-08

11.0

D2856600851

Abrasion Strip



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Abrasion Strip

Pick:

Qty Part number Description

Batch

2 D2856-600-851 Abrasion Strip

26650

47 07-05-08

12.0

D28931

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Support

Pick:

Qty Part number Description

Batch

2 D2893-1 Support

29073

27 07-05-08

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 07/05/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng.	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/20/2007 1:52:06 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD X-TUBE EXTENDED HEIGHT GEAR (-011)

Job Number: 31372

Part Number: D205596101

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

MS2192024

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number

Description Batch

4 MS21920-24

Clamp

103002

25 07-07-08

14.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install Abrasion strips per QSI 035 position using DT8582. Install supports and clamps per Dwg

D205-596-101. Torque clamps to 80-100 in lb. Seal edges of support using Sikaflex

27 07-07-08

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DD 7-5-8

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-596-101

Location:

REV: 2

SP 07/05/09

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/05/09
W 07-05-09

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

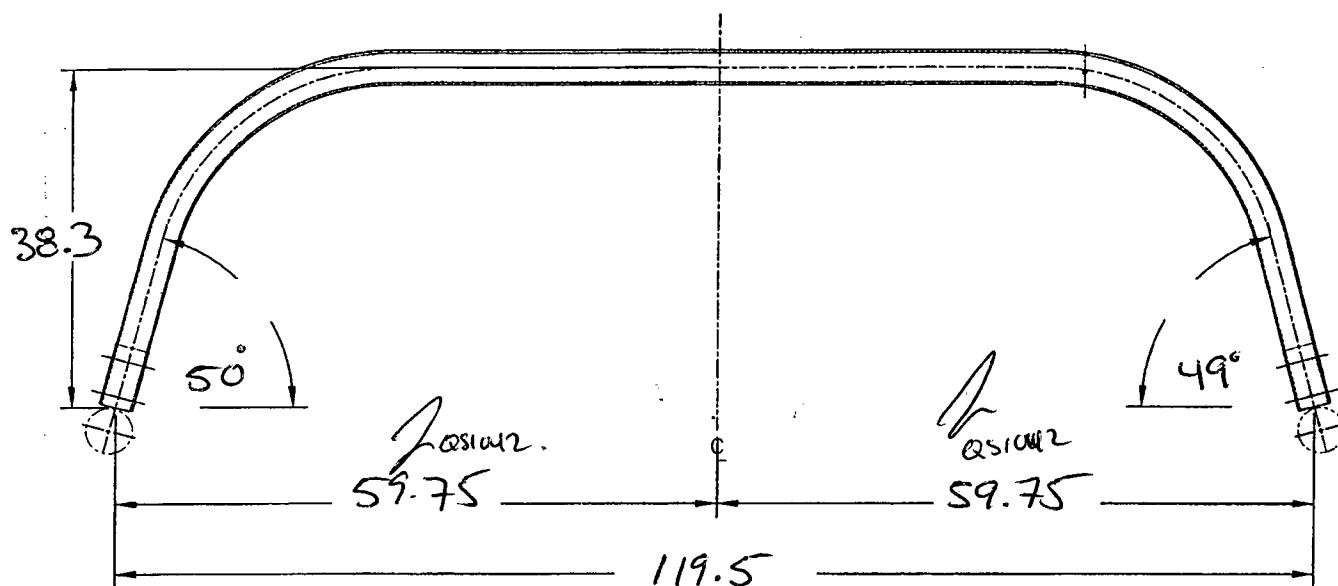
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	31372
Description: Crosstube High-High Fwd		Part Number:	D205-596-101
Inspection Dwg: D205-596-101 Rev: A		Page 1 of 1	

Required Dimension	Min	Max
Height	38.2	38.4
1/2 Span	59.5	59.7
Angle	49	52
Total Span	119.0	119.4

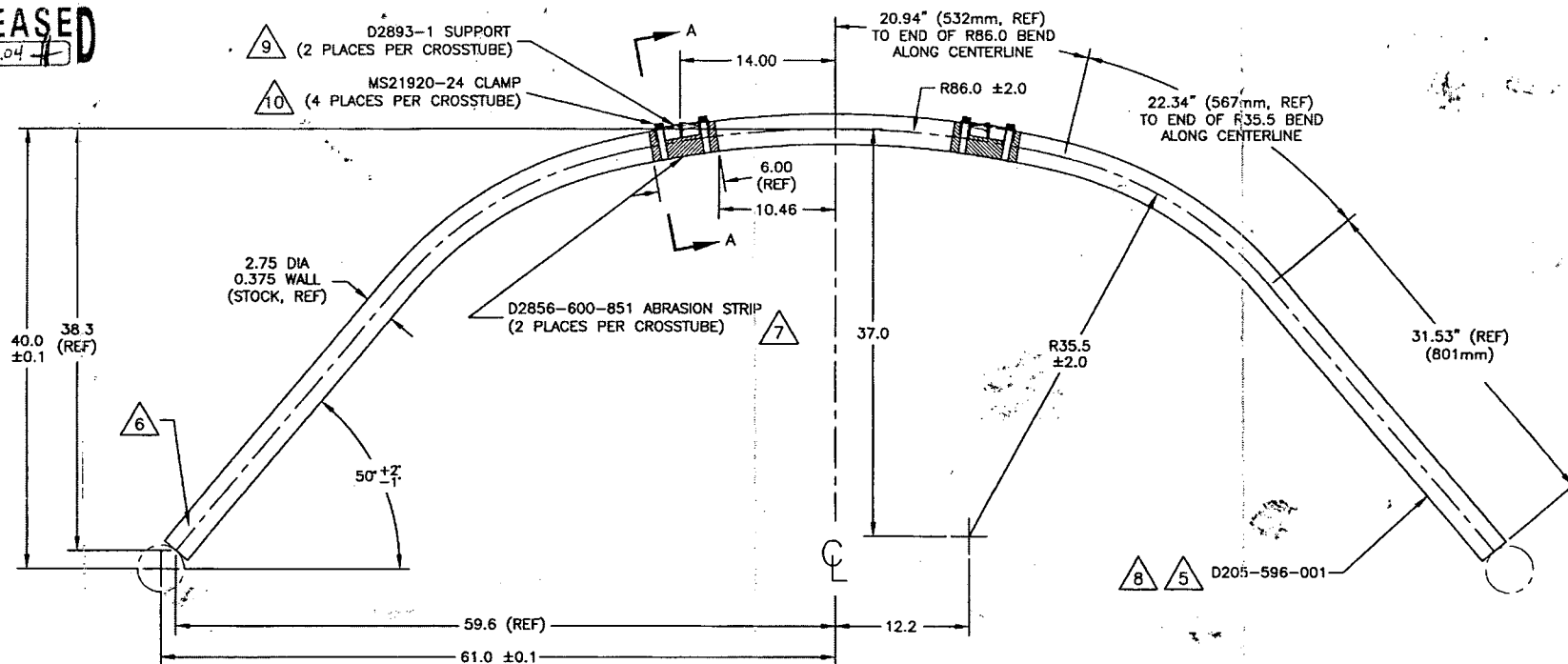


Comments

QC15 Inspection	<i>20703.28</i>
Date	

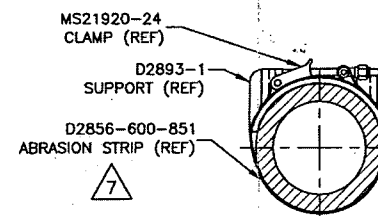
Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM <i>[Signature]</i>	<i>[Signature]</i>

RELEASED
02.06.04








GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) MATERIAL: MANUFACTURE FROM D5005-180
FINISHED LENGTH = 149.60
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 6) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS
- 7) INSTALL D2856-600-851 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2893-1 SUPPORT, PER QSI 035
- 8) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005\"
- 9) SEAL EDGES OF SUPPORTS USING SIKAFLEX-241/-291 SEALANT (OPTIONAL)
- 10) TORQUE CLAMPS 80\"



SECTION A-A
SCALE 2:5

A		02.05.27	NEW ISSUE	
DESIGN 		DRAWN BY 		DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
CHECKED 		APPROVED 	DRAWING NO. D205-596-101	REV. A
DATE 02.05.27		TITLE XTUBE ASS'Y (HI-HI FWD)		SHEET 1 OF 1 SCALE
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NO. 31372
WORK ORDER
WITH PUT NOTICE
DIRECT TO AMENDMENT
CONTROLLED COPY
ENGINEERING
RETURN TO
SHIP COPY